

Date: Wednesday, 02/04/2008 3:39:30 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CROSSTUBE EXTRUSION		
Job Number	: 38338			Part Number	: D6006129		
Estimate Number	: 10028			Drawing Number	: D6006 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/04/2008	S.O. No.	:	Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: LANDING GEAR	Due Date	: 26/09/2008	Qty:	35
Previous Run	: 34690			Um:	Each		
Written By	:			Comment	: Est Rev:C 04.06.15 Added tolerance to Step 2 KJ/JLM		
Checked & Approved By	: <u>JD</u> 08.04.03						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:		Description :				
1.0	PG		PURCHASING				
							
Comment: PURCHASING							
Issue P/O: <u>6063</u>				<u>208/04/04</u>		<u>35</u>	
a) Order as per Dwg D6006 b) Material: 3.250 x 0.515 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d) Minimum tensile yield strength = 66 ksi e) Tolerance are per ASTM B210 (see details on Dwg D6006) f) Material certification required							
2.0	D6006129P		Crosstube material				
							
Comment: Qty.: 1.0000 Each(s)/Unit Total : 35.0000 Each(s) Crosstube material <u>AS 08/09/16</u> <u>(S)</u>							
3.0	PACKAGING 1		PACKAGING RESOURCE #1				
							
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <u>AS 08/09/16</u> <u>(X35)</u>							
4.0	QC6		DIMENSIONAL CHECK				
							
Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D6006 <u>S 08/02/17</u> <u>(46)</u>							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
7.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>X-tube cell</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



BT 08-09-17 *40*

08/09/18 *H*

MF 08-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng.	Action Description Chief Eng	Sign & Date			

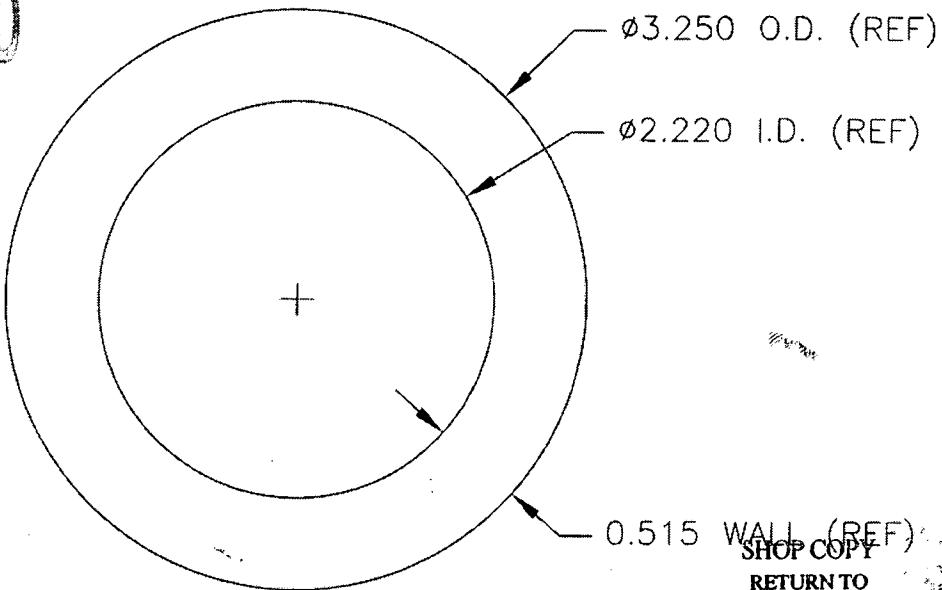
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6006
DATE		REV. A
00.11.17		SHEET 1 OF 1
		SCALE 1:1
A	00.11.17	NEW ISSUE

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24



NOTES

- 1) D6006-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 129" LONG TUBE: D6006-129

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38338

- 2) MATERIAL: 3.250 OD x 0.515 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.052 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

Kunde: Dart Aerospace Ltd.

Cient:

 1270 Aberdeen Street
 K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 1261/08

Cert No.: / No. du certificat:

Bestellnummer: FO00006063

Order No. / No. de commande

Auftrag: 29104/5

Our Reference/Notre Reference:

Produkt:
Product / Produit:
Spezifikation:
Specification:
Werkstoff:
Material / Matière:
Abmessung:
Size / Dimension:
Zeichnung:
Marking/Marquage:
Lieferung:
Shipped Material / Matérial délivré:

Dart Aerospace Ltd.

 1270 Aberdeen Street
 K6A1K7 Hawkesbury, ON Canada

Rohre nahtlos gepresst

Tubes seamless extruded

AMS - QQ - A - 200/11E; Spezifikation Dart Aerospace D6006

7075

Zustand: T 6511

Temper/État

3,250 INCH x 2,220 INCH x 0,515 INCH x 129,000 INCH

D6006-129 3.250 X 0.515 X 129

 ALUNNA - Cert No. 1261/08 - 7075 - T6511 - Cast No. 81992 - AMS - QQ - A - 200/11 - 3.250" OD x 0.515" Wall-
 Heat Lot No. 1835 - ALUNNA Order Conf. No. 29104/5-1 - P.O. 00006063

Stück kg

40 1062,00

Chemical Analysis / analyse chimique

1. Chemische Analyse

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ Test No.	min.			1,2	2,1	0,18	5,1						
	max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20				

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
	77,0	66,0				
1	84,390	77,720	11,0		168	1835 - 40 pcs.
2	84,825	78,300	11,0		164	
3	84,825	78,735	11,0		170	

 RMS: outside: 15 - max. 15,41 μ m

**Ergebnis der
Prüfungen:**

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

**Test results:
Résultats:**

 We confirm that the delivery has been tested and applies to the agreements made on receipt of the order
 Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

Packinglist ALUnna AG

Customer No.	PO. 00006063
/s/ Diana	29104/5
Date:	08.21.08

Date: 08.21.08
We hereby declare that the wooden packing material are totally free from bark and apparently

Boxmarking:

Dart Aerospace PO. 00006063
Made in Germany
Dest. Hawkesbury Ont. Canada

free from live plant pests